

Date: Thursday, 17/08/2006 3:17:37 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLEVIS
<b>Job Number</b> : 28212	
<b>Estimate Number</b> : 10640	
<b>P.O. Number</b> : <u>N/A</u>	<b>Part Number</b> : D34535
<b>This Issue</b> : 17/08/2006 <b>S.O. No.</b> : <u>N/A</u>	<b>Drawing Number</b> : D3453 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <u>N/A</u> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 28190	<b>Material</b> : <u>N/A</u>
<b>Written By</b> : <u>ll</u>	<b>Due Date</b> : 31/08/2006 <b>Qty:</b> .6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : EST. REV. A 05.11.16 NEW ISSUE EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304R0750	Inventory
<b>Comment:</b> Qty.: 0.1733 f(s)/Unit Total : 1.0395 f(s) AISI 304 SS round bar 0.750" dia. (M304R0750) Batch: <u>M101694</u> <u>22.5"</u> <u>MS 06/09/02</u> <u>12</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA581 & DWG D3453 , FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>MS 06/09/02</u> <u>12</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>MS 06/09/02</u> <u>12</u>		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> CONVENTIONAL MILLING MACHINE, 1- Drill as per dwg D3453 2-Deburr as per dwg D3453 <u>MS 06/09/06</u> <u>12</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:17:37 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28212

Part Number: D34535

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Handwritten:* 06/09/06

*Handwritten:* 12

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*Handwritten:* S.G.

*Handwritten:* 06/09/06

*Handwritten:* 12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Handwritten:* ST 438

*Handwritten:* 06/09/08 (12)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Handwritten:* 06/09/11

*Handwritten:* 12

Job Completion



*Handwritten:* u 0609-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

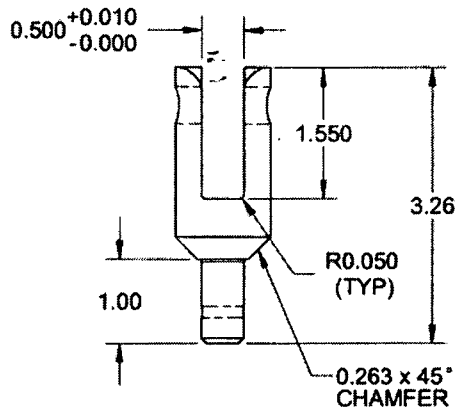
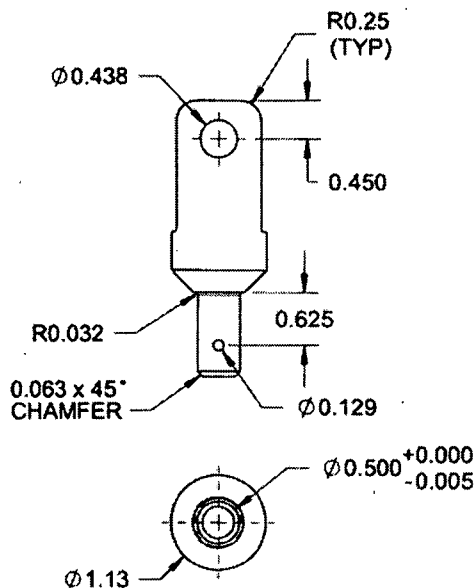
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



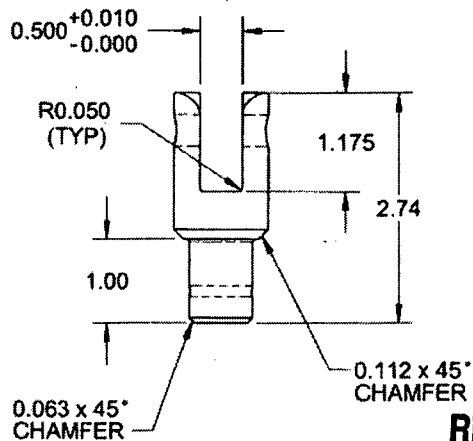
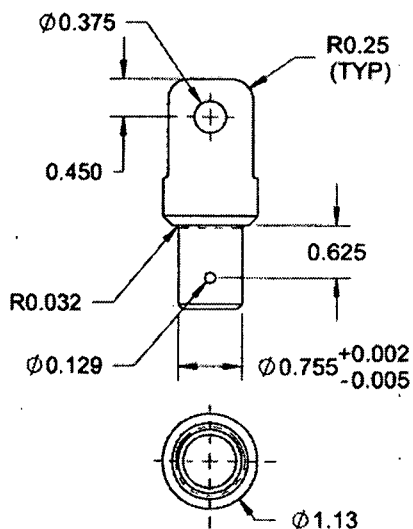
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	



**D3453-1 CLEVIS**

RELEASED

05.12.09 *[Signature]*



**REFERENCE ONLY**

**D3453-3 CLEVIS**

**NOTES:**

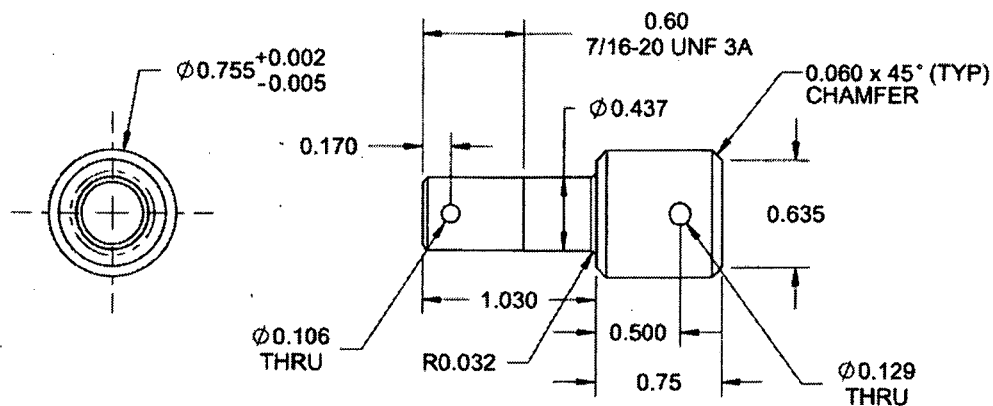
- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3453</b>	REV. A SHEET 2 OF 2
DATE <b>05.09.02</b>		TITLE <b>CLEVIS</b>	SCALE 1:1

**RELEASED**05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28212
<b>Description:</b> Clevis		<b>Part Number:</b> D3453-S
<b>Inspection Dwg:</b> 3453 , <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.755	+ .002 - .005	.752	✓			
.170	± .010	.170	✓			
7/16-20		O.K. as per chart	✓			
.032	± .010	.032 MS				
φ.129	+ .003 - .001	.128				
φ.437	± .010	.434				
φ.100	+ .004 - .001	.105				
.75	± .030	.748	✓			
.500	± .010	.500				
.635	± .010	.640				
.06x45	± .010	.06x450	✓			
1.03	± .030	1.028	✓			
7/16-20 thread		avec mesure hors pige = .4487" → ma mesure = .4470				MS

<b>Measured by:</b> MS	<b>Audited by:</b> J.G.	<b>Prototype Approval:</b>
<b>Date:</b> 06/09/06	<b>Date:</b> 06/09/06	<b>Date:</b> 06-09-07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	